

Date: Tuesday, 13/05/2008 1:23:14 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LATCH
Job Number : 39216	
Estimate Number : 12772	
P.O. Number :	Part Number : 41232 200 002 003
This Issue : 13/05/2008 S.O. No. :	Drawing Number : 41232-200-002 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 13/05/2008 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35203	Material :
Written By : <i>08-05-13</i>	Due Date : 05/06/2008 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-03-05 JLM	
Est Rev:B Now on Doosan Lathe 08-05-13 JLM Verified	
By:DD	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	M2024T3R1875	2024 T3 ROUND BAR 1.875
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Comment: Qty.: 0.3675 f(s)/Unit Total : 2.2050 f(s)
2024-T3 Round Bar 1.250"
Batch: *117892*

20 08/05/23

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE \

1-TURN AS PER FOLIO FA688 & DWG 41232-200-002 ,

FOLIO REV: *1*

DWG REV: *1*

2-DEBURR AS REQUIRED

3-Tap 1/4"28NF

4-GRIND RADIUS BY HAND

20 08/05/23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/05/23

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/08/28

Date: Tuesday, 13/05/2008 1:23:14 PM
User: Jean-Luc Menard

Process Sheet

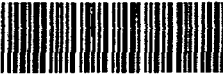
Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH

Job Number: 39216

Part Number: 41232 200 002 003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 7040

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

C208/08/28

(7)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Pc 8/9/9 (7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S08/09/10 (7)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57365

Pc 8/9/10 (7)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

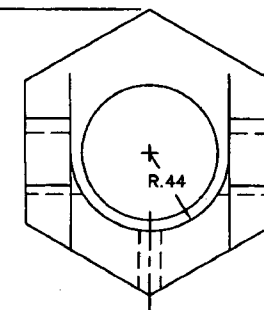
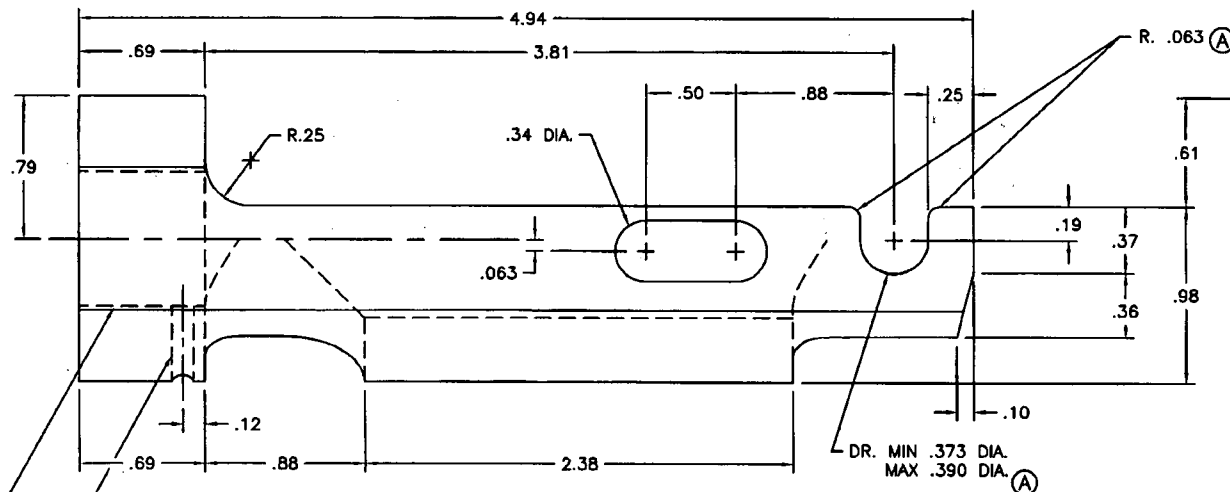
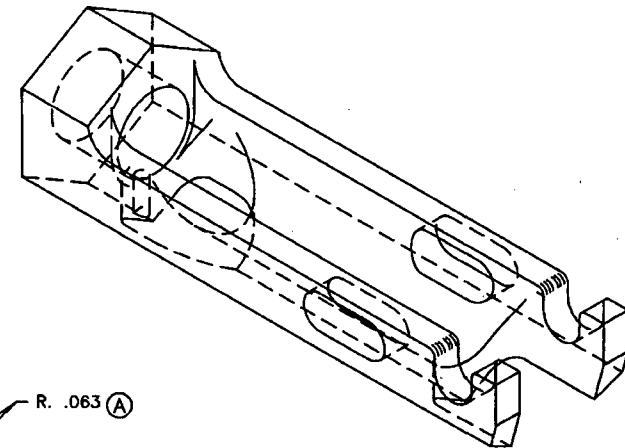
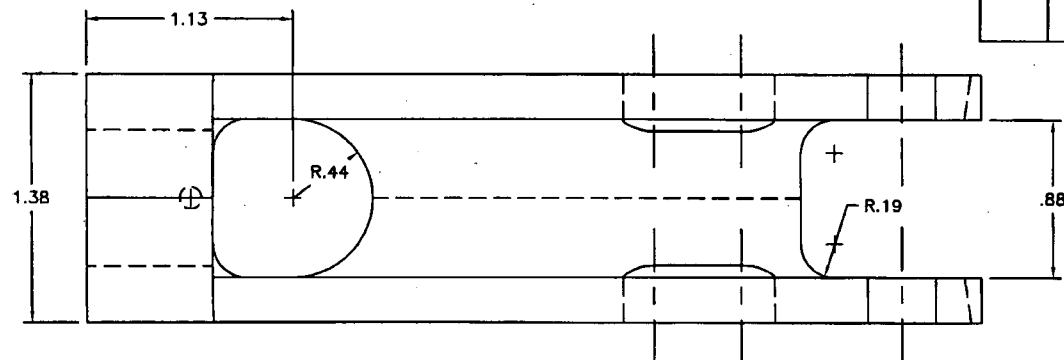
08/09/10 (7)

Job Completion



MF 08-09-10

REVISION							
LETTER	DFTSMAN	DATE	DESCRIPTION			APPROVED	DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.				
MINOR CHANGE - FAR 21.95			CHECK	D. MURPHY	2/17/03		



-001 TUBE

DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D
TO DRILL HOLE) (A)

3/4"-20 THD.

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39216
ENGINEERING

1	MS21209F4-15	INSERT				
	-005	PIVOT ARM	△	1.00 DIA. x 3.56	2024-T4, T351 ALUM.	
	-003	LATCH	△	1.11 x 3.50	2024-T4, T351 ALUM.	
	-001	TUBE	△	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.	
	-005	PART NO.		NAME	STOCK SIZE	MATERIAL
						MATL. SPEC
						ZONE
LIST OF MATERIAL						
NO. REQ'D PER ASSY						
PROPRIETARY RIGHTS NOTICE						
UNLESS OTHERWISE SPECIFIED						
X ± .1						
X ± .03						
X ± .010						
ANGLES 1/2°						
FRESH						
HEAT TREAT						
DFTSMAN D. NELSON 2/18/02						
CHECK D. MURPHY 2/18/02						
STRESS						
PREL. ENGR.						
TITLE STEP ACTUATOR COMPONENTS						
DWG. SIZE C SCALE 2:1						
DWG. NO. 41232-200-002						
SHT 1 OF 3						
REV. A						
NEXT ASSEMBLY						
NO.						
2 41232-200-001						
DNN						
REQ'D PER ASSY						

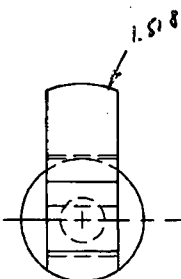
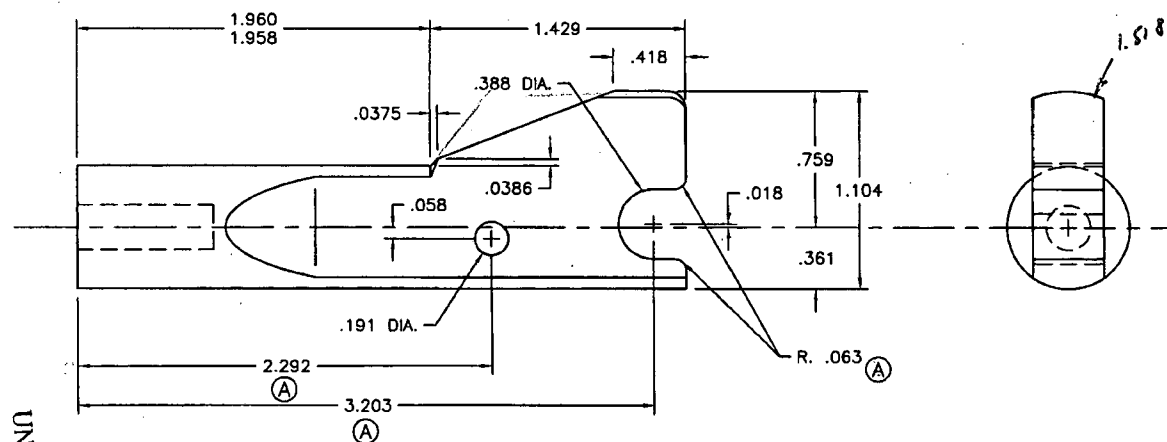
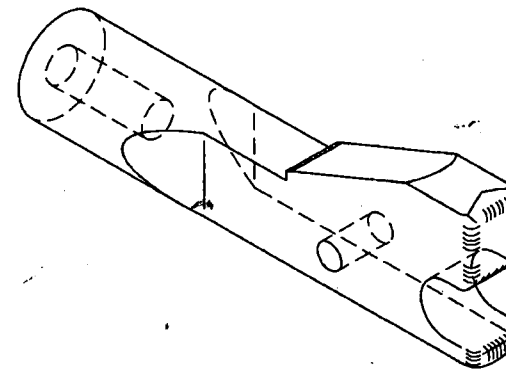
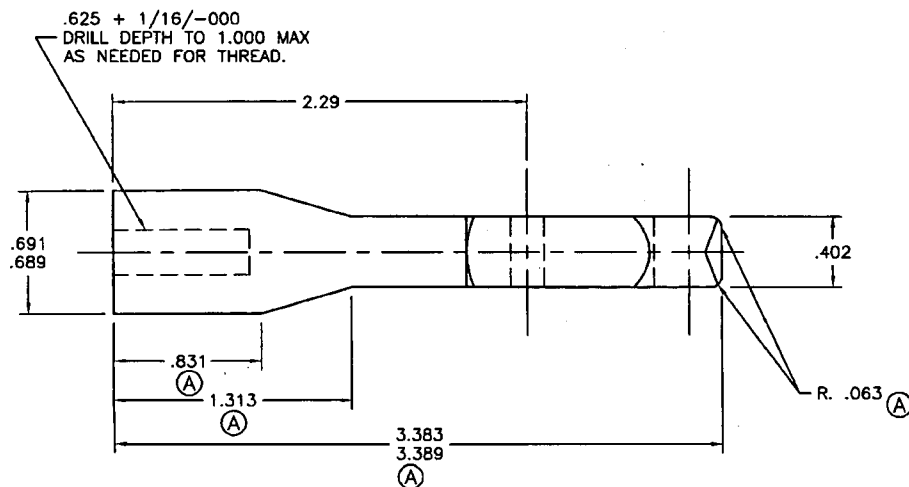
△ ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2 DYED BLACK.

NOTE:

UNLESS OTHERWISE SPECIFIED
X ± .1
X ± .03
X ± .010
ANGLES 1/2°
FRESH
HEAT TREAT
DFTSMAN D. NELSON 2/18/02
CHECK D. MURPHY 2/18/02
STRESS
PREL. ENGR.

TITLE STEP ACTUATOR COMPONENTS
DWG. SIZE C SCALE 2:1
DWG. NO. 41232-200-002
SHT 1 OF 3
REV. A

Eric Aviation, Inc.



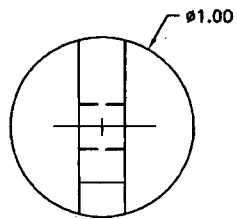
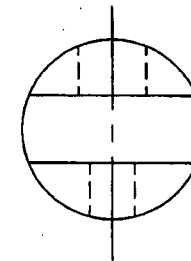
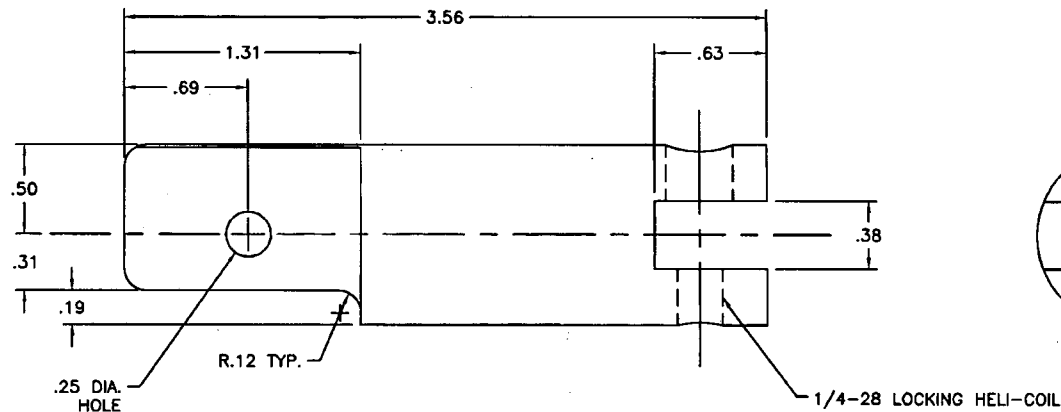
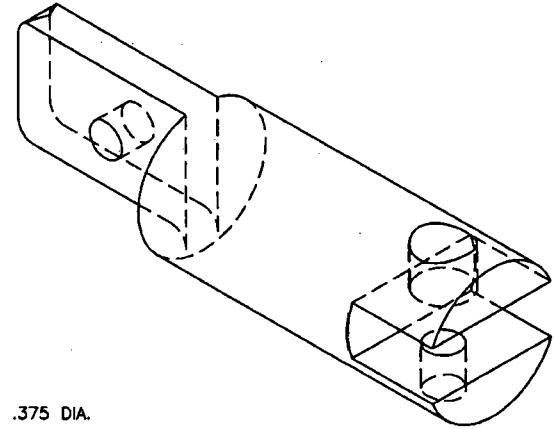
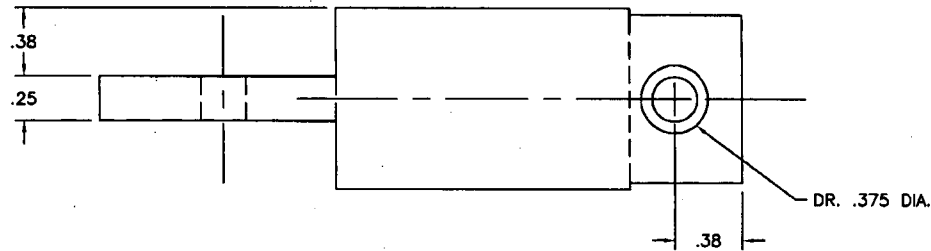
-003 LATCH

SHOP COPY
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WORK ORDER
NO. 31216

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Era Aviation, Inc.

FILE	REV.	ENCL. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 2 OF 3	A



-005 PIVOT ARM

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GOING DOES NOT APPLY TO VENDOR PARTS.

Era Aviation, Inc.

TITLE	SIZE	DWG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 3 OF 3	A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

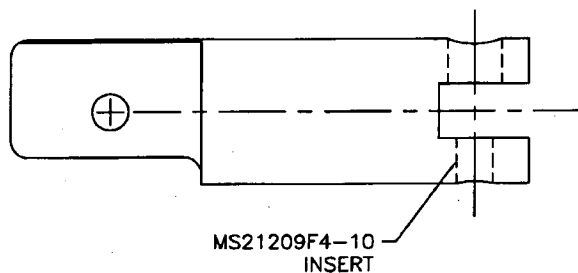
IS

1	MS21209F4-10	INSERT
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WAS

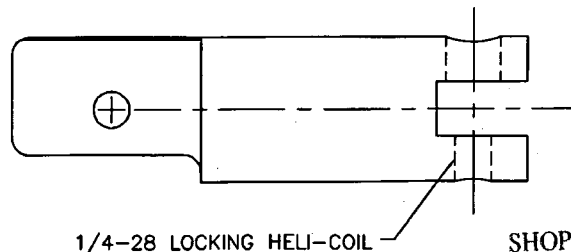
1	MS21209F4-15	INSERT
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39214

CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

DART AEROSPACE LTD		Work Order:	39216
Description: Latch		Part Number:	41232-200-002-003
Inspection Dwg:	Rev: A	Page 1 of 1	

41232-200-002

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.29	+/- .030	2.29				
.691/.689	.002	.689				
.831	+/- .010	.840				
1.313	+/- .010	1.313				
3.383/3.389	.006	3.384				
.402	+/- .010	.402				
R.063	+/- .010	R.063				
1.960/1.958	.002	1.960				
1.429	+/- .010	1.420				
.0375	+/- .010	.0375				
.388	+/- .004 - .001	.387				
.418	+/- .010	.418				
.0386	+/- .010	.0386				
.058	+/- .010	.058				
.191	+/- .004 - .001	.191				
2.272	+/- .010	2.290				
3.203	+/- .010	3.203				
.018	+/- .010	.018				
.759	+/- .010	.759				
1.104	+/- .010	1.104				
.361	+/- .010	.361				
R.063	+/- .010	R.063				
1/4-28 x 1.000	N/A					

Measured by: <i>PC</i>	Audited by: <i>SA</i>	Prototype Approval: <i>N/A</i>
Date: 08/08/28	Date: 08/08/28	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

67864

08-Sep-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITENO. DE COMMANDE: PO00007040
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	41232 200 002 003 - B	

BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL
OVER

Last Modified on 09-Sep-2008

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient
Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air
ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

TNM**ANODISATION et PEINTURE TNM INC.****FACTURE
INVOICE**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

67864 Rev.00

08-Sep-2008

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

NO. DE COMMANDE:**PURCHASE ORDER/ PO00007040****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	7	7	41232 200 002 003 B -	\$0.00	\$0.00
			MINIMUM CHARGE		\$100.00
					SUB TOTAL: \$100.00
					TPS/GST: \$5.00
					TVQ/PST: \$0.00
					TOTAL AMOUNT DUE: \$105.00

BLACK ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

No de TPS / GST #: 891559734 RT

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE

No de TVQ / QST #: 1019307154 TQ000

CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.